

Date: Monday, 11/19/2007 4:02:23 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 35827		
Estimate Number	: 10334		
P.O. Number	: N/A	Part Number	: D2804042
This Issue	: 11/19/2007 S.O. No. : N/A	Drawing Number	: D2804 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: 34018	Material	: N/A
Written By	: <u>JA 07 11 20</u>	Due Date	: 12/12/2007
Checked & Approved By	: <u>JA 07 11 20</u>	Qty:	10 Um: Each
Comment	: Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM Est Rev:G As per Rev C 06-11-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D28042	STA 155 Bracket
-----	--------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STA 155 Bracket

Pick:

Qty Part Number

Description

Batch

1

D2804-2

Bracket

B 28413 (1)
 B 28302 (4)

B 29410 (5)

SA 07/12/13 (10)

2.0	D28052	Stop
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Stop

Pick:

Qty Part Number

Description

Batch

1

D2805-2

Stop

B 33600 (5)
 B 31033 (10)

ml ~

3.0	D2809	Bushing
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick:

Qty

Part Number

Description

Batch

1

D2809

Bushing

B 35671

SAD 07-12-31

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 & ~~52009~~ into arm as per Dwg D2804

ml 07/12/13 x10 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:02:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 35827

Part Number: D2804042

Job Number:



Seq. #: Machine Or Operation: Description:

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 *07-12-13* *(410)*

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105914

Bl

07-12-14

(10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-10

(210)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press Fit D2809 as per Dwg D2804

SAN 07-12-31 (10)

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	<i>M105426</i>

07/12/21

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	<i>M105792</i>

07/12/21

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch	Washer
<i>M105164</i>				
A/R	LPS-3	Corrosion Spray	<i>M104929</i>	<i>07/12/21</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 10 Date: 08/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:02:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 35827

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

04/12/21

18

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/02

x10

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 149*

AS 08/01/02

x10

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D2801/03

Job Completion



2008/1/2

U

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

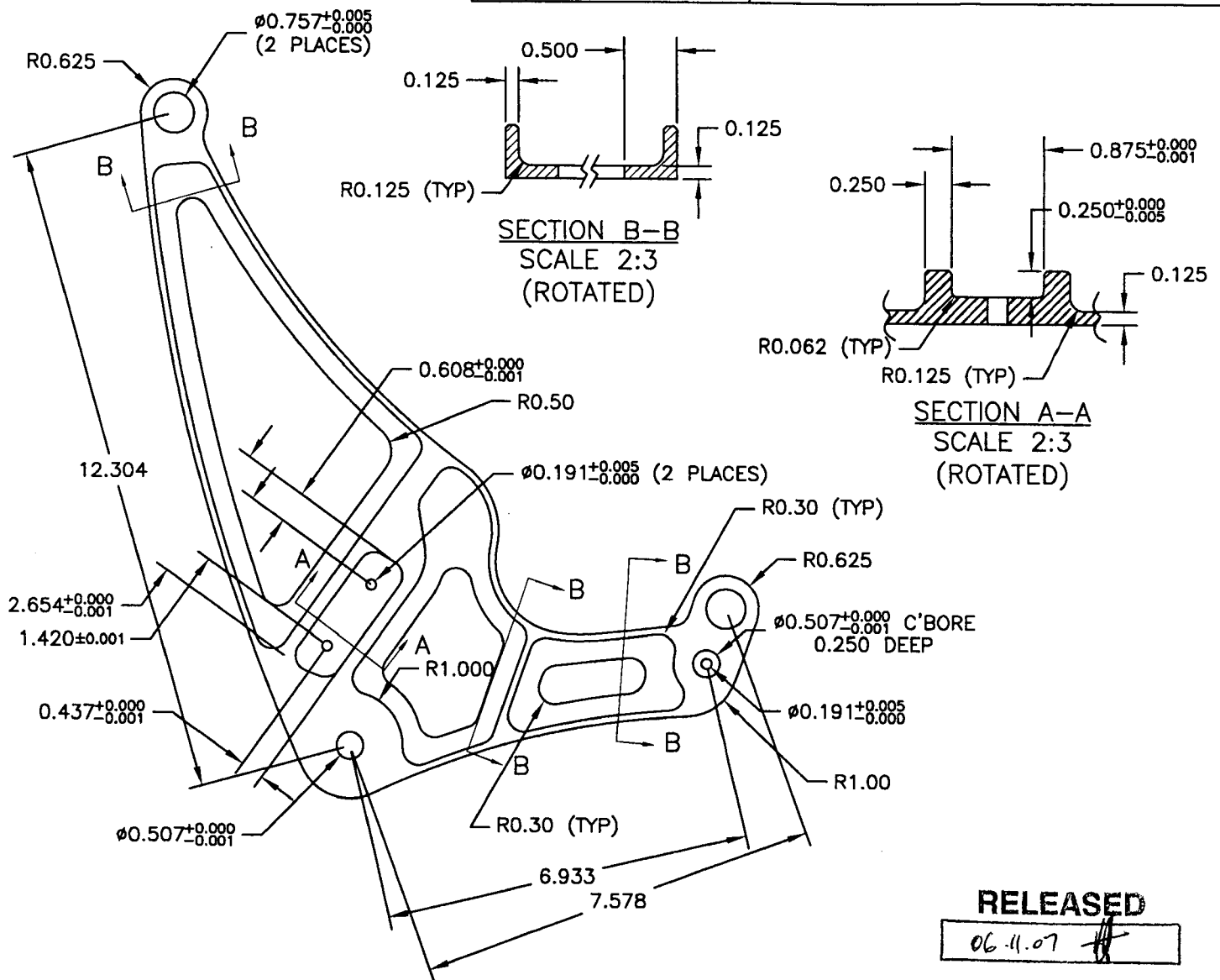
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**RELEASED**

06.11.07 #

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)



- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

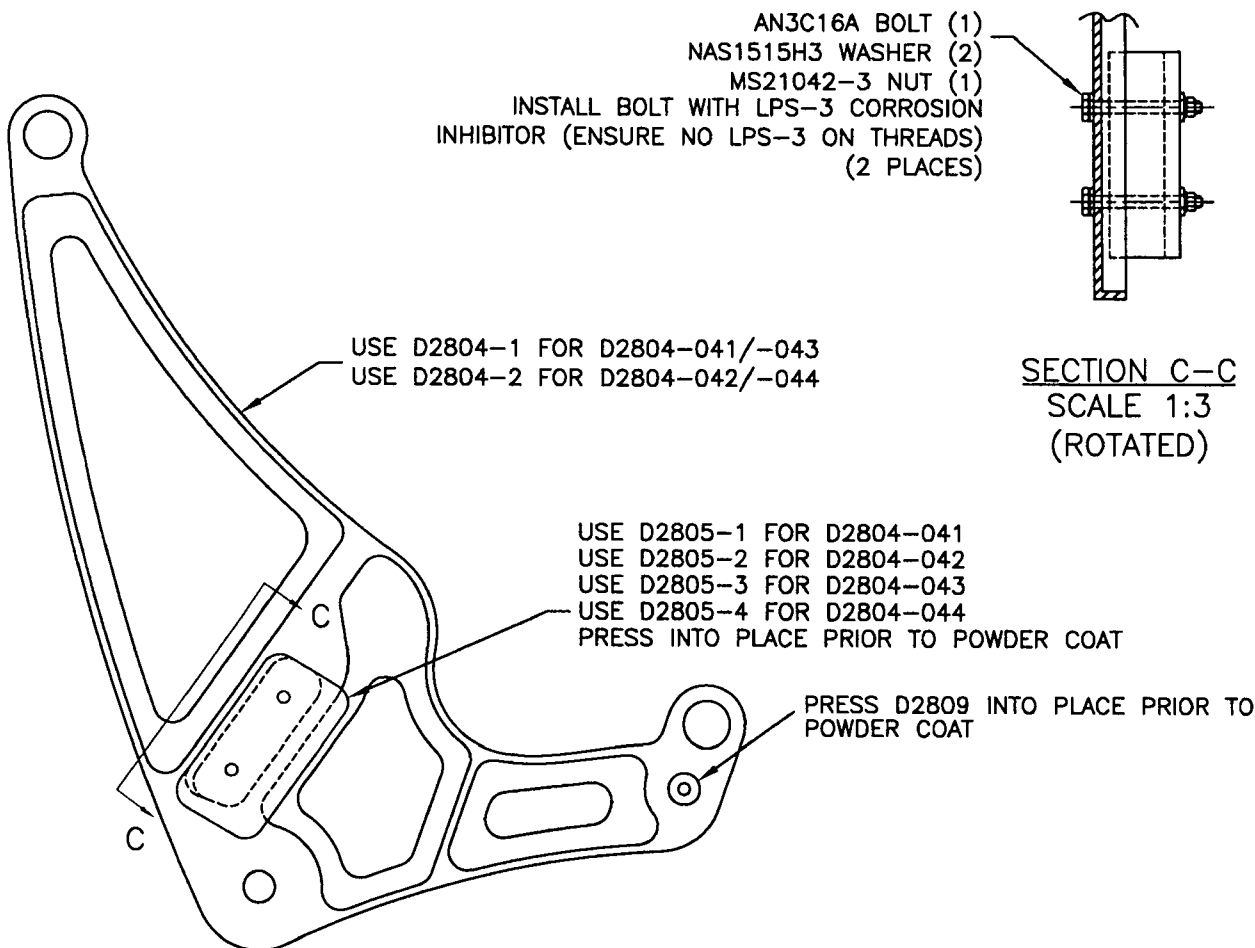
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16	TITLE STA 155 BRACKET		SCALE 1:3



D2804-041/-043 BRACKET ASS'Y (SHOWN).

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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